\*92899\*

Page 1

November-12-12	2 8:58:12 AN	1		^978	399^						Page 1
Item ID: Revision ID: Item Name:	646.4003 AS350 Cable	Cutter w/o Fixed Provisi	ons	Accept	*N900	<b>040</b>	100	)* :	Setup Start Stop	ı VI -	S1* S2*
Start Date: Required Date: Reference:	12/11/2012 : 03/12/2012	Start Qty: 10.00 Req'd Qty: 10.00	*10° *10°		Cust Item I Customer:	D:			-		17
Approvals:	Process Pla QC:	in: MLJ	Date: 12-11-			ite:		1	Run Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr						~·J		···	Stamp
646.4000	A		18								,
*1 \\n^* \\ DC \\ Document Control	,	DOCUMENT CONTROL  Memo Photocopy bl	uefile & type labels per	0.00 0.00 PPP 646.4003	DAS 6 9-89	12/9		10	D	10/m	1-13 (16
110											
*110 * Packaging Packaging		Pick Kit  Memo		0.00				_/0			DAS 33 -9-89 /3-1
120 *120*		QC4- 100% Inspect kits for	or completeness	0.00	DAS	1a		las			
QC Quality Control	·	Memo		0.00	9-69 (3)	219		10			· · <u>- · · ·</u> ·

		L	•
QA:	Date:		

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

	•							•		QA Closed:	Dat	e:		
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIR OIGE	'				Rework	7		Skid-tube	Crosstube		Water Jet	Engineering		
Part N	o.			,	Scrap	<b>┤                                    </b>		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
		4 ,		<del></del>	Use-as-is	1		oforming	Finishing		e/Packaging	Other		
NCR N	lo.				Work Order Update	1		Large Fab	Composite	,	Supplier			
					, <u>L</u>									
Root				Descri	ption of work order update	In	itial	Ac	ction	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	n QC Inspector		
Doc/Data														
Equip/Tooling		j												
Operator	_													
Material												,		
Setup														
Other														
Process	_													
Supplier	_													
Training	_					1								
Unapproved		<u> </u>												
						AULT	CATE	SORY						
Landir	ng Gear			_	General					7	Г			
1	Bending			<u> </u>	Bend	-	Grain		<u> </u>	Ovalized		Pressure/Forced		
	Centre N	ot Conce	ntric to (	D/S	BOM/Route	$\mathbf{H}$	Hardwa			Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged		-	on incomplete		Part Incorre	<b>•</b>	Weld		
		Crimped.			Burrs		nstruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte	nance		Part Moved				
Ĺ	Heat Trea	at			Countersink		Mislabe	led	<u></u>	Positioned V	~ r	<del></del> 1		
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other		
	Ripples in	n Bend			Drill Holes	Щ	Offset							
Į	Torque V			1 <u> </u>	Drawing	Out of Calibration								
L	Turning S	Sequence			Finish		Out of S	equence						
	Mayo/Tu	lict in Tuk	30		Folio	1 1	Jutcida	Dimensions						

November-12-12 8:58:12 AM 646.4003 Item ID:

**Required Date:** 03/12/2012

Accept

\*N900040100\*

Date:

Setup Start

Item Name: **Start Date:** 

**Revision ID:** 

12/11/2012

**Start Qty: 10.00** Req'd Qty: 10.00

AS350 Cable Cutter w/o Fixed Provisions

\*10\*

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

**Process Plan:** 

Date: Date: Tooling:

SPC (Y/N):

0.00

Date:

Run

Sequence ID/ Work Center ID

**Operation** Description Set Up/ **Run Hours**  Tool ID

Tool # Plan Accept Code Oty

Reject Qty

Reject Insp. Number Stamp

130

\*130\*

Packaging

Packaging Packaging

0.00 Memo

Identify and pack for shipping as per PPP 646.4003

140

QC21- Final Inspection - Work Order Release

0.00

\*1//0\*

QC Quality Control

Memo

0.00

W13-12-11

NCR: Ye	es / No				WORK ORDER NON-O	CON	NFORM	ANCE / UPI	DATE	-		
<u>-</u>										QA Closed:	Date:	
Nork Order	·:				DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-i	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	1	T		Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance		ief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling Derator Material etup Other rocess upplier raining												
					F.	AUL	T CATE	GORY				
Landing	g Gear				General		•			-		
	Cracks Crushed, Cuffs Heat Tre Inspection	on Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset		Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Vaves in E		'' <u> </u> -	Drawing Finish		ł	Calibration Sequence				
1	Turning Sequence     Finish				ı	IUUL OI S	equence					

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

646.4003

\*646 4003\*

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

**Start Date:** 12/11/2012

**Required Date:** 03/12/2012

**Start Qty: 10.00** 

Required Qty: 10.00

C	o	m	m	e	n	ts	:
_	-			_			-

IPP REV:A 12.12.23 NEW ISSUE DD VERF-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3301 0 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	* 6 9-89	Manufactured	No				Each	0.0000	**	10 8×10 2×10	00125		DAS 33
646.3001 *6463901 Lower Cutter Assembly	AS B Sey	Manufactured	No				Each	0.0000	** 8+	10 9289	X1 B1 a 1 DAS 33	749,7	DAS 32 9-89
646.2910 * <b>646.291</b> 0 Deflector	* 6 9-89	Manufactured	No				Each	0.0000	**	10	1019 30 3 110 10 7 19 110 - U - 3 1	45 ~~ 8	DAS DASS
16.3510 6 <u>46.3</u> 510 rut	DAS	Manufactured	No				Each	0.0000	** 2X	10 /4 /6 2 3	10013	DAS 8	33 9-89 X <i>B / Old</i>
ର୍ଷ୍ଟ୍ରମ <b>ନିଧାର ଅଗ୍ରମ</b> ଆ	6 9-89	Manufactured	No				Each,	0.0000	**	10 /o <b>2</b>	!	33 9-89 DAS -33 - 9	DAS 26 9-89
6 <sup>3512</sup> 6463512	DAS 6 9-89	Manufactured	No				Each	0.0000	** 77	10 (94/ (		9-89 AS 3×	06/14//
6 4 6 3 5 4 5 4 5 4 5 4 5 4 5 4 5 4 5 4 5 4 5	DAS 6 9-89	Manufactured	No				Each	0.0000 🖚	**	10 10.465	83 :	89 PAS D/ 83 89	13.0129

												DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE					
	-											QA Closed:	Dat	te:	
Work Ord	or:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Work Ord	٠		<u>.</u>			Rework	7		Skid-tube	Crosstube		]	Water Jet		Engineering
Part	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	$\dashv$	Quality
	•			<del></del>		Use-as-is	1		noforming	Finishing		4	e/Packaging	$\sqcap$	Other
NCR	No.					Work Order Update	1		Large Fab	Composite			Supplier		
												-			
Root	1				l	ption of work order update	ı	Initial	Acti			Sign &		Ì	
Cause	$\longrightarrow$	Date	Step	Qty	(	or Non-conformance	Cł	nief Eng	Descr	iption		Date	Verificatio	<u>n</u>	QC Inspector
Doc/Data	Ш														
Equip/Tooling	Ш														
Operator	Ш													1	
Material	Ш														
Setup	Ш													1	
Other	Ш														
Process	Ш														
Supplier															
Training															
Unapproved															
			***			F	AUI	LT CATE	GORY						
Landi	ing G	ear				General		_				_			
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
	П	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/L	Inclear		Part Lost/M	issing		Wrong Stock Pulled
	П	Cuffs				Contamination		Mainte	nance		Г	Part Moved			•

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short Drill Holes

Drawing

Finish

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

NAS1149F0332P

646.4003

\*646 4003\*

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

Purchased

**Start Date: 12/11/2012** 

**Required Date:** 03/12/2012

Start Qty: 10.00

Required Qty: 10.00

1,182;000

Loc Code

Loc Code

0.0000

Each

DAS 33

9-89

DAS
6
<del>9</del> -89

<u>Location</u>	Loc Qty
275	206
122441	206
ST275	776
117735	13
119225	8
121259	138
121825	14
122063	600
17317	3
ST295	200
123352	200
	Each

MS21042L3

Purchased

No

No

126333

1160

123900

DAS 33 9-89

*M	S21042 -3*5	
Nut .		
1		

DAS	
6	
<u>೯</u> ೩-೨	

Location		Loc Qty
316		619
	122452	619
ST300		225
	117885	32
	119017	55
	119075	138
ST314		1251
	123265	1251
ST317		321
	122141	321
		Each

	DAS

Manufactured

DAS 6

9-89

DAS 33

**Shop Packet Print** 

November-12-12 8:58:16 AM

									DQA:	Date:	,		
NCR: Yes	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:			
Work Order:		-			DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No.					Rework Scrap		Skid-tube Crosstube  Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality		
NCR No.					Use-as-is Work Order Update	1	noforming Large Fab	Finishing Composite		re/Packaging Supplier	Other		
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	cription	'Date	Verification	QC Inspector		
Doc/Data Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process	]												
Supplier													

			FAU	LT CATEGORY		
Landing	Gear	General		_	_	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulied
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink			Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
. [	Wave/Twist in Tube	Folio		Outside Dimensions		

Training Unapproved November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

646.4003

\*646 4003\*

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

**Start Date:** 12/11/2012

**Required Date:** 03/12/2012

Start Otv: 10.00

Required Oty: 10.00

	* •					;	Start Qty:	10.00	Required Qty:	10.00	
MS. **  Screen	MS24694-854*	Purchased	No	·	Each	41.0000	**	50 12743	۵	AS DAS 33	
	6			Location	Loc Qty	Loc Code			9	.89	59
	9-89			ST289	41	<u>Bot cout</u>					1
	-			116805	41						
AN3	13A	Purchased	No		Each	56.0000	احد.	10			
- 公/	NN3_13 Δ *						**	1237	~ Q D.	AS	Da
Bolt								125/	<u>7</u> يو	3 89	- 55
÷	DAS			Location	Loc Qty	Loc Code			3-	09	<b>19</b>
	6			ST351	56						
	9-89			104746	26						į.
	£			120910	30						
646.	10000	Manufactured	No		Each	0.0000		10			1
*6	3463711 * 600						**	939	27 DAS		20
Clip	<u> </u>						A I		9-89		
646.	3712	Manufactured	No		Each	0.0000		24/0255			₩09
*6	3719* Das	·				•	**	8x 939	) 1-9	DAS	
Clip	Q.eô							8× 9393	114	9-89	
646.	381.1	Manufactured	No		Each	0.0000		10	DAS	200	2.3 *
\$ * G	346 3844 *						**	166714	33	CP86	
Rad	ius Block OAS								9-89	300	
AN3	-6A 6	Purchased	No		Each	282.0000	**	20			
7.3	NN3=6'A'*						**	12×12619	2 DAS	. i	3-11-1
· Bolt								121/26/9	74 33		2
	das 6			<b>Location</b>	Loc Oty	Loc Code			9-89		
	9-89			ST512	282					2	89
	, J			117441	34						
				121166 122814	13 200					, i	
4				122993	35						
											1

NCR: Y	'es / No				WORK ORDER NON-O	CONFC	ORMAN	CE / UP				<del>, -</del>
					<b>.</b>	T				QA Closed:	Date	:
Work Orde	er:				DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
					Rework	7 <b> </b>	Skid-	tube	Crosstube		Water Jet	Engineering
Part No.					Scrap	1 <b>1</b>	Mach	ining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Th	ermofori	ming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Work Order Update	]	Large	e Fab	Composite		Supplier	
								<u>,                                      </u>				
Root		:			ption of work order update	Initia			tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling				•								
Operator												
Material	_										:	
Setup												1
Other				:								
Process	_											
Supplier 			•				ļ					
Training	-						İ					
Unapproved	<u> </u>	<u> </u>			F	ALLITICA	L ATEGORY	,				
Landie	ng Gear				F General	AULI CA	ATEGORY					
Landin	Bending				Bend	Gra	in		E,	Ovalized		Pressure/Forced
	Centre N	nt Conce	ntric to		BOM/Route	$\vdash$	dware			Over/Under	tolerance	Temperature/Cure
	Cracks	or concei	intine to	b) 5	Broken/Damaged	$\vdash$	oware pection Inc	complete		Part Incorre	<b>⊢-</b>	Weld
}	Crushed/	Crimped		-	Burrs	-		ncomplete/	/Unclear	Part Lost/Mi	<b>├</b>	Wrong Stock Pulled
ŀ	Cuffs	crimpeu.	-	-	Contamination	$\vdash$	intenanc	•	Officieal	Part Moved	133111g	
ļ	Heat Trea	at			Countersink	Mislabeled Positioned Wrong					Vrong	
•	Inspectio		Tube		Cut Too Short	$\vdash$	read		-	Power Loss/		Other
ŀ	Ripples in	-		-	Drill Holes	Offs			<u> </u>	1. 54461 2033/		Tourie
Ì	Torque W		Extrusio	, <b>⊢</b>	Drawing	$\vdash$	of Calibra	ation				
L				1	1	1						

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

646.4003

\*646 4003\*

Location.

ST289A

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

**Start Date:** 12/11/2012

**Required Date:** 03/12/2012

**Start Qty: 10.00** 

Required Qty: 10.00

MS24694-S55

Purchased No Each 126.0000

Loc Code

1,242.000

Loc Code

127305

DAS 33 9-89

646.3610

DAS 6 9-69

Manufactured No

No Purchased

36 119307 33 120910 121444 2 ST306 90 122151 90 Each

Loc Qty

Each

0.0000

102275

DAS 33

DAS 9-89

DAS 6 9-29 Location Loc Qty ST512 1242 115371 46 117423 121 119355 200 120187 38 121185 122416 500 122800 331 Each

60

Purchased

No

Location Mezz

100993

Loc Oty 235 235

Loc Code

235.0000

MS27039-1-12

			DQA:	Date:	<u>'</u>
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	,		
			QA Closed:	Date:	

									QA Closed:	Date			
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fall Use-as-is Thermoforming Finishing			Fab Prod. Eng. Coor. Qualining Rec/Store/Packaging Oth				
Root					ption of work order update	Initial		tion	Sign &	_			
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Descr	ription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling	_												
Operator		]								-			
Material	_					1							
Setup	_												
Other	_												
Process													
Supplier	_												
Training	-			  - 	•								
Unapproved		<u> </u>				AULT CAT	ECORY						
1 1		•		·	General	AULI CAI	EGURT						
Landin	g Gear Bending				Bend	Grain			Ovalized	Г	Pressure/Forced		
-	Centre No	at Cancai	atric to (	\-	BOM/Route	Hardw		<u> </u>	Ovalized Over/Under	toloranco	Temperature/Cure		
ŀ	Cracks	or concei	itile to t	),, ⊢	Broken/Damaged	<del></del>	tion Incomplete	<u> </u>	Part Incorre	<del>-</del>	Weld		
	Crushed/	Crimpod		<u> </u>	Burrs		ctions Incomplete/l	Uncloar	Part Lost/Mi				
F	Cuffs	cimpeu.		<b>—</b>	Contamination	<b></b>	tenance	Officieal	Part Moved	1331118			
<b>⊢</b>					Countersink	Mislat		-	Positioned V	Mrong			
}	<b>⊢</b>				Cut Too Short	Misre		<u> </u>	Power Loss/		Other		
}	Ripples in	•	, and	-	Drill Holes	Offset		<u>.                                    </u>	J. OWC. 2033/	20180	Other		
F	Torque W		xtrusion	, <del> -</del>	Drawing	$\vdash$	Calibration						
-	Turning S			·	Finish	$\mathbf{H}$	Sequence						
F	Wave/Tw			<u> </u>	Folio	⊢	le Dimensions						

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

646.3716

646.4003

\*646 4003\*

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

**Start Date: 12/11/2012 Start Qty: 10.00** 

Required Date: 03/12/2012

Required Qty: 10.00

Gauge Bracket

6 9-89

DAS

Manufactured No

0.0000

10 3×102552 7×93198

DAS 33 9-89

MS20426AD5-7

Purchased

No

ST318

Each 927.0000

Each

DAS 33 9-89

Rivet

MS24694-S54

DAS 6 9-89

Purchased

No

Location Loc Qty 927 101340 927

Each 36.0000

Loc Code

Loc Code

0.0000

101340

20

DAS 125535

33 9-89

DAS 6 9-89

Location Loc Qty ST289A 120142 120361 ST303 31 122814 31 Each

124326

DAS 33

9-89

MS27039-1-21

MS27039-1-20

**SCREW** 

Purchased

No

DAS 5.89

> No Purchased

Location Loc Qty Loc Code ST291 96 115935 96 ST292 94 115935 94

Each

20

DAS 33

13-11-27

Screw

DAS 6

November-12-12 8:58:16 AM

**Shop Packet Print** 

Page 5

			DQA:	Date:	
ICR.	Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

										QA Closed:	Date:	
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No			Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root		[		Descri	I iption of work order update		nitial	Acti	ion	Sign &		Ţ
Cause	Date	Step	Qty		or Non-conformance		ief Eng	Descr		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator								-				
Material												
Setup		1										
Other												
Process						İ						
Supplier												
Training -								i				
Unapproved									·····			
					·	FAUL	T CATE	GORY	· · · · · · · · · · · · · · · · · · ·			
Landin					General					7	_	
<u> </u>	Bending			_	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
_	Centre N	ot Conce	ntric to (	o/s	BOM/Route	$\vdash$	Hardwa			Over/Under	<u> </u>	Temperature/Cure
-	Cracks			-	Broken/Damaged		1	on Incomplete		Part Incorre	<b>├</b>	Weld
1	Crushed/	Crimped.		_	Burrs		•	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
-	Cuffs			ļ	Contamination		Mainte		_	Part Moved		
-	Heat Trea			<u> </u>	Countersink	-	Mislabe		<u> </u>	Positioned V		<b>-</b>
	Inspectio		Tube	<u> </u>	Cut Too Short	<u> </u>	Misread	i	<u>L</u>	Power Loss/	Surge	Other
-	Ripples in			-	Drill Holes	-	Offset	- 111				'3
-	Torque V			<sup>ነ</sup>	Drawing		ł	Calibration			<del></del>	
-	Turning S			<u> </u>	Finish		1	Sequence				
	Wave/Tw	vist in Tul	oe e	1	Folio		Outside	Dimensions				

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

No

Parent Item:

646,4003

\*646 4003\*

Location

122814

123352

123522

ST306

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

Start Date: 12/11/2012

Required Date: 03/12/2012

**Start Oty: 10.00** 

Required Qty: 10.00

M\$27039-1-19

Purchased

Each

Loc Qty

132

32

50

Each

Each

132.0000

DAS 33

9-89

\*MS27039-1219\*

DAS	
6	
9-89	

Manufactured	No

Custom Washer

AN3-11A

Purchased No 50 Each 0.0000 Each 496.0000

Loc Code

Loc Code

DAS 33 9-89

142×125654

Bolt

DAS
6
9.69

Loca	tion	Loc Oty
ST35	1	150
	123525	150
ST51	2	. 346
	110865	46
	115457	100
	123352	200
		Each

9-89

600.0990

DAS Magnabond 6398 Part A (One 4 oz can)9

600.0991

600.1012

Magnabond 6398 Part B (One 4 oz can)

Sealant (One 6 oz Semkit)

Purchased No

Purchased

Purchased

No

No

0.0000

0.0000

\*\*

11545

DAS 33 9-89

DAS

33

DAS 33 9-89

DAS 33

9-89

											DQA:	Date:	
NCR: Ye	es /	No				WORK ORDER NON-O	100	VFOR	MANCE / UP	DATE	•		
											QA Closed:	Date:	***
Work Ordei	r·					DISPOSITION AGAINST				AGAINST DE	PARTMENT	PROCESS	
Work Order	' ·				<del></del>	Rework	]		Skid-tube	Crosstube		Water Jet	Engineering
Part No	0.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	o					Work Order Update	]		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Δα	ction	Sign &		
Cause	Di	ate	Step	Qty	`	or Non-conformance	1	nief Eng		cription	Date	Verification	QC Inspector
Doc/Data				1					-				• • • • • • • • • • • • • • • • • • •
Equip/Tooling							ļ						
Operator													
Material													
Setup													
Other				, ,					-				
Process		ļ					l						
Supplier	_												ļ
Training	_						]						
Unapproved									<u></u>		<u></u>		
							AUI	LT CATE	GORY				
Landin	<del>-</del>				_	General	_	1			٦		,
	Ben	_				Bend		Grain			Ovalized		Pressure/Forced
1 1	Cen	tre No	t Concer	ntric to	o/s	BOM/Route	1	Hardwa	re		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Required Date:** 03/12/2012

**Start Date:** 12/11/2012

### **Picklist Print**

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

646.4003

\*646 4003\*

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

										5	Start Qty: 10.00	Required Qty:	10.00
	*600.0129  *600 VHB Tape	0129*	DA 6 9-8:		Purchased	No			Each	0.0000	** 8712554	// DAS // 0 33	DAG
	*600.1013 *600	1 <del>()1:3</del> *	Das 6		Purchased	No			Each	.0.0000	₹50 50 ** 125/	9-89 54 DA	9479 S DAS
Ĺ	Primer 646.3910 <b>*646</b>	3910*		DAS 6	Manufactured	No		,	Each	0.0000	** 10× 100/	9-89 3-5	DAS
,	Shim 646.3911 *646	3911*	DAS 6	P- <b>8</b> 9	Manufactured	No			Each	0.0000	** \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	9-89	B106729 J.S.
١.,	Shim 646.3912 *646	F THE P	9-89 DAS 6 9-89		Manufactured	No			Each	0.0000	** () 40 - 4 × 10 2 20 × 10 3	9-89 27/ DA	DAS IS O
•		391 <b>3</b>	i	DAS	Manufactured	No .			Each	0.0000	** // 100 13	9-8 , DAS	9 DAS
	Shim AN3-12A *AN3	<b>-1-2-</b> A* <sub>0</sub>	AS	-69	Purchased	No			Each	79.0000	** 20	33 9-89 )DAS	989 [3-(1-13
	Bolt		3				<u>Location</u> ST351		<u>Loc Qtv</u> 79	Loc Code		33 9-89	9-89
							121825 122407 123352		10 . 18 50				

		DQA:	Date:	
ICD: Voc / No	WORK OPDER NON-CONFORMANCE / LIDDATE			

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORE	MANCE / UP	DATE	QA Closed:	Da	ite:
Work Ord						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Quality Other		
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verificatio	on QC Inspector
Doc/Data													
Equip/Tooling			}										
Operator							1						
Material													
Setup													
Other													
Process							İ						
Supplier	Ш		1										
Training													
Unapproved			i								ļ.,		
							FAUL	T CATE	GORY				
Landi	ng (	1				General	_	1			٦		
	<u> </u>	Bending			.	Bend	<u> </u>	Grain		<u> </u>	Ovalized		Pressure/Forced
	<u> </u>	Centre No	ot Concei	ntric to	o/s	BOM/Route	_	Hardwa		<u></u>	Over/Under		Temperature/Cure
	<u> </u>	Cracks				Broken/Damaged	<u> </u>	1 '	ion Incomplete		Part Incorre		Weld
						Wrong Stock Pulled							
	-	Cuffs			<u> </u>	Contamination		Mainte			Part Moved		
	$\vdash$	Heat Trea				Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V	•	
Inspection Strip in Tube Cut Too Short				Misrea	d	<u>L</u>	Power Loss/	Surge	Other				
		Ripples in				Drill Holes	<u> </u>	Offset					
		Torque W	/aves in E	xtrusio	n	Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-12-12 8:58:16 AM

Work Order ID: 92899

\*92899\*

Parent Item:

646.4003

\*646 4003\*

Parent Item Name: AS350 Cable Cutter w/o Fixed Provisions

**Start Date:** 12/11/2012

**Required Date:** 03/12/2012

**Start Qty:** 10.00

Required Qty: 10.00

MS27039-1-16 Purchased No

Each 106.0000

DAS 33 9-89

13-11-13

\*MS27039-1-16\*

DAS

Location		Loc Qty	Loc Code
ST291		6	
	119902	1	
	121444	5	
ST306		100	
	122993	100	



												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	100	<b>NFORM</b>	MANCE / UP	DATE					
			•								ſ	QA Closed:	Da	ite:	
Work Ord	or:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
WOIK OIG	ет.	· ·				Rework	7		Skid-tube	Crosstube	٦	☐ Water Jet			Engineering
Part	No.					Scrap	1 ]		Machining	Small Fab	┥	Pro	d. Eng. Coor.	$\boldsymbol{\vdash}$	Quality
						Use-as-is	1		noforming	Finishing	┪		e/Packaging	-	Other
NCR	No.					Work Order Update	]		Large Fab	Composite			Supplier	$\cdot \square$	
<u> </u>				,		·			,		_				***************************************
Root						ption of work order update		nitial		tion	1	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	4	Date	Verification	'n	QC Inspector
Doc/Data	Ш														
Equip/Tooling											-				
Operator	Ш														
Material	Ш														
Setup														ļ	
Other				]											
Process															
Supplier															
Training															
Unapproved															
						F	AUL	T CATE	GORY		_				
Land	ing (	Gear				General		_				ı		_	
		Bending				Bend		Grain				Ovalized		L	Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re			Over/Under	tolerance		Temperature/Cure
Cracks Broken/Damaged Inspection Incomplete Pa						Part Incorre	ct		Weld						
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
Cuffs Contamination				Contamination		Mainte	nance			Part Moved					
		Heat Trea	at			Countersink		Mislabe	eled			Positioned V	Vrong		
1		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		$\neg$	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

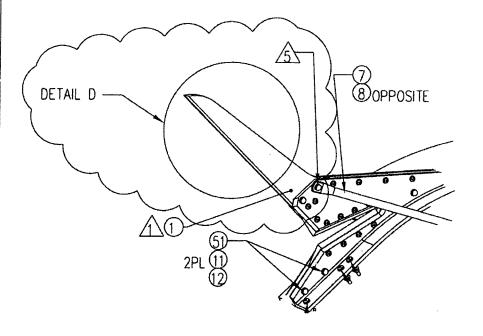
<u>'</u>									
	ENGINEERING	CHANGE NO	TICE NO	0307	9		SHEE	T 1	 JF ·1
APICAL	DWG NO. 646	5.4000 R	REV: A	PREPARED BY:	N.CAP .	DATE: 03/	/21/11		T ON DWG MUNINC
INDUSTRIES, INC.	DWG TITLE:	AS350 CABL	E CUTTER	SS KIT			**************************************	I U IIVC,	M ONTING
	APPROVED BY: ENGR	PBaro	MFG 5	without	oc //	coursel Fr. s	EFF <sup>1</sup>	VEXT O	———— RDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-RE√ISE D-DELETE	REASON: CREA	TED FIXED							
SHEET 1,	REF REF J REF 65	SHETT COLL  FOR THE PROPERTY OF THE PROPERTY O	PROPERTY OF THE PROPERTY OF TH	2		S2   600,990   MARKED	BRACKET  BRA	G-11A  G-11A  G-11A  G-11A  G-11A  G-11A  G-11A  G-11A  G-11A  G-11A  G-11B  G-	
DOCUMENTS EFFECTED:	X MDL	☑ INSTALL INS	TRUC 🗵 I	CA 🛛 B	CHANGE CA			REQUIRED	)

	ENGINEERING CHANGE NOTICE NO. 03046 SHEET 1 OF 1
APICAL	DWG NO. 646.4000 REV: A PREPARED DATE: 01/24/11 EFFECT ON DW
	DWG TITLE: AS350 CABLE CUTTERS KIT
	APPROVED BY: ENGR Brance MFG Davy Poula OC Maure Legan EFF: NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED GPS MAUNT KIT, FIN 65. REVISED DRAWING VIEWS!
K-ME VISE D-DELETE	ADDED NOTE /7).

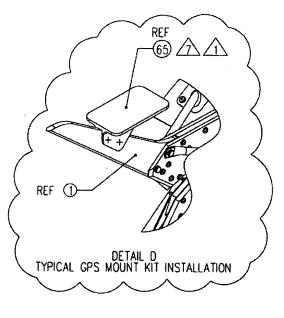
## SHEET 1, ZONE B1 IS:

AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ONTO F/N 1.

## SHEET 2, ZONE A4 IS:

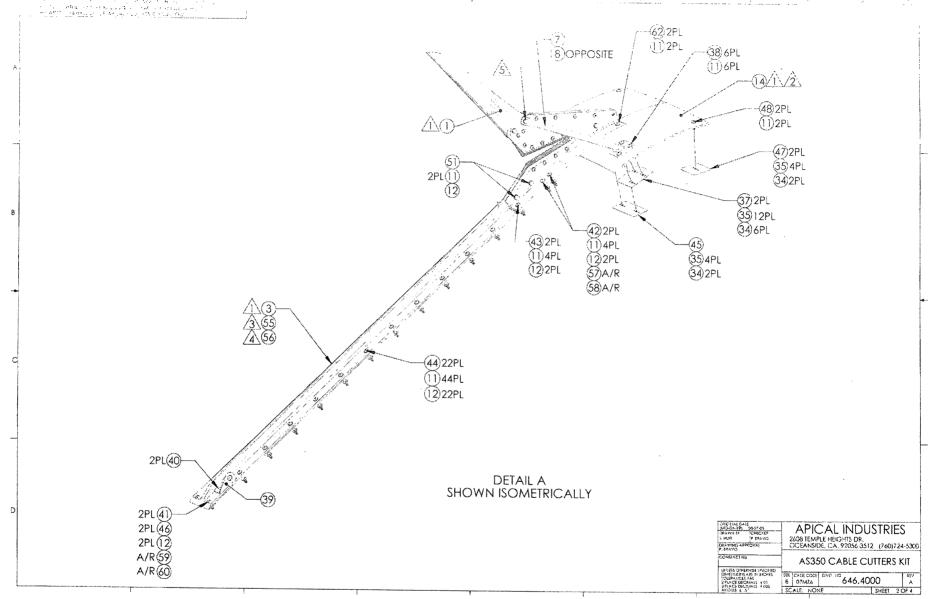


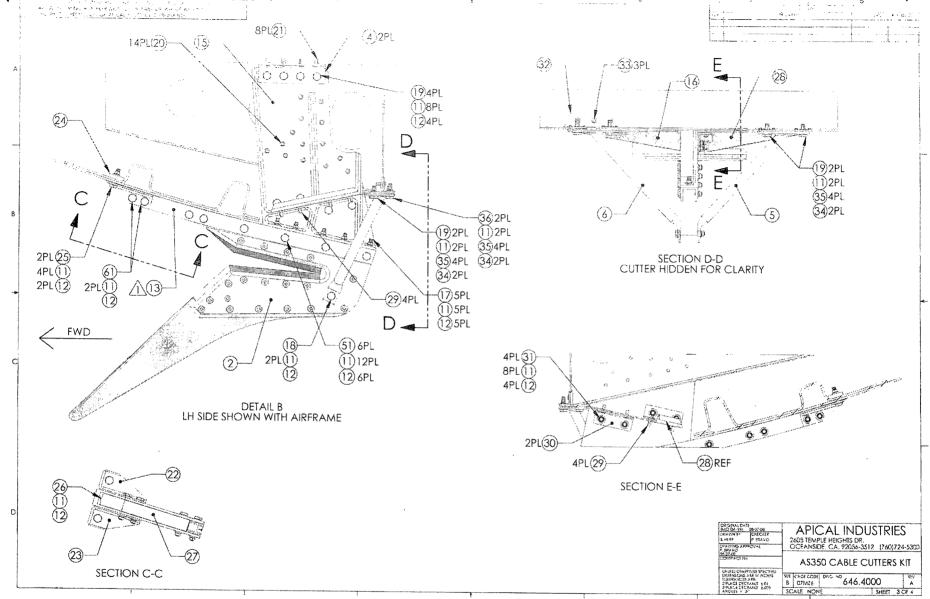
### SHEET 2, ZONE B2 IS:



65	Α	647.5701		GPS MOUNT	T KIT			A		
F/N	TC	PART NUMBER	QTY QTY		DESCRIPTIO	]N		MATERIA	L	SPECIFICATION
DOC	CUME	ENTS EFFECTED:	ا		STALL INSTRUC	□ ICA	CHANGE MAJOR	CATEGORY	DER RE	VIEW REQUIRED ES Ø NO

Service of the servic		(*) (*)********************************	2 -322 - 12 - 12 - 12 - 12 - 12 - 12 - 1	
NOTES:	Visit Low Joined ECN(s)	· · · · · · · · · · · · · · · · · · ·	l.	
AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL CAPS AND FILLET EDGES	03046, 03079	5 56 1800.1013	52441	
INSTALL F/N 14 WITH F/N 52 & 53	e doctor of tribundada a front of the control of th	1 55 500.0129	FRIMER A VHB TAPE A SEALANT THE OR	4,,, 1
	,	: 53 500,0991	MACHGBOND 6398 FARTS	
3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE VENDOR: MCMASTER-CARR P/N 7.5935A651		8 5 601,2826	MACINCIBOUS 6098 PAPLA BOLL ANS	-TA
		2 50 (446.3814 )	WIPER BRACKET SCREW 452761	
3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE VENDOR: R.S. HUGHES P/N 021200-24216		2 48 601.1365	SCREW KNOWN	
REUSE FASTENERS FROM F/N 1		4 46 646.3715	DOUBLER CUSTOM WASHER	
USE WASHERS AS REQUIRED AS SHIMS TO OBTAIN BEST FITMENT		2 22 44 601,1948	DOUBLER SCREW MS2401	39.1.10
FEG 200 HUDGING US VERROIKED VS SLIMS IN ORIGIN REST HIWEN!			SCRFW MS2701 SCREW MS2701	33-1 %
		2 41 601.2829	SCREW MS244	Wa <b>55</b> a
		1 39 646,3716	RIVET NS2042 GAUGE BRACKET	
		0 38 691.1953	SCREW NS220 STRUT DOUBLER	19-1-17
		2 33 601,2824	BOLT AND CORRES	
		18 34 600.0795	CIUTPLATE MS211	047-3
C DETAIL A		1 32 646,3813	RIVET M52047 STRUT BRACKET M52047	3AD57
/		4 3) 501.2822 2 30 646.3812	BOLT ANS GUSSET BRACKET	330
, , v, di xA viiiiiiiii		8 29 601.2564	RIVET M57,047	0e05-6
DETAIL		1 27 646.3610	FILLER	
DETAILC		26 601,2830 2 25 601,2825	SCREW MASONA BOLT AND	
	and the second s	2 25 601.2825 1 24 646.3811 1 23 646.3712	RADIUS BLOCK CLIP	
	15 San San San San San San San San San San	22 646 37 1	CUP	
		14 20 601.2020	RIVET 10.0000	13.5-3
646.4002	the second secon	10 19 601.2823	BOLT ANS	
646.4002		5 17 601,2912	SCREW JAS246 GUSSET	
		1 15 646.3210	TROPPUZ	
646.4001		1 13 646.3110	DOUBLER CHANNEL	
		16 134 11 601.1607	LOCKNUT M52:0 WASHER M65:14	
LDETAIL B		1 10 646.3411	RH WIPER DEFLECTOR  LH WIPER DEFLECTOR	
		1 8 546.3513	STRUI	
	64 601.3151 WASHER NAST 1495/28505	3 6 646.3511	STRUT	
2	63 601.2911 SCREW A52469553 2 62 601.2637 SCREW M527039-1-16	2 4 646,3810	STRU! . BRACKET	
	2 61 601.2763 BOUT AND TO	1 3 646.2710	DEFLECTOR LOWER CUTTER ASSY	
	1 60 646,3913 SHIM 4 59 646,3912 SHIM	1 1 646.3301	UPPER CUTTER ASSY	
	58 646.3911 SHIM	646.4001	ASSIST WITER DEFLECTOR AIT ASSIST CABLE CULTERS AIT	
Company Landson	# HND# PART# DESCRIPTION MAIL SPEC.	QTY FIND # PART #	DESCRIPTION MA PARTS LIST	SPEC.
		NEXT ASSY (S) ORGANIC DATE ORGANIS OF CHARMES OF CHARMES OF CHARGES	APICAL IND	USTRIFS
		1 HUFF P BRAYO	2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3	15.12 #7401794.50cm
		P. FEAVO DE-27 OS CONTEACT NO		
		1	A\$350 CABLE C	OTTERS KII
		DNLS OMERNE PECFED  DNLS OMERNE PECFED  GORALACE PECFE  PACE SICKAI LOSS  APOLE LA	B 07M26 646	.4000 🕺





> DETAIL C LH SHOWN EXPLODED RH OPPOSITE

> > CONTROL DATE
> >
> > MODEL TO CONTROL
> >
> > DRAYNEY ENCOURE
> >
> > 1 MEET ENCOUR
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> > DRAYNEY ENCOUR
> >
> > DRAYNEY PROVIAL
> >
> > DRAYNEY AND CONTROL
> >
> > CONTROL NO.

APICAL INDUSTRIES
2603 TEMPLE HEIGHTS DR.
OCEANSIDE CA. 92056-3512 1760]724-5300
AS350 CABLE CUTTERS KIT

UNIESS CHMERWISE SPECKED
DIVIDIDADING AND IN DICTIES
OF LOCK DECEMBES 2005
PACED DECEMBES 2005
PACED SECRETARIS 2005
FACILIFIANCE 25

SERVICE 25

SERV

| SCALE NONE | SHEET 4 OF 4

	ENGINEERING CHANGE NOTICE NO. 03079	<del>)</del>	SHEET 1 JF 1				
APICAL	DWG NO. 646.4000 REV: A PREPARED BY:	N.CAP DATE: 03/2	21/11 EFFECT ON DWG				
INDUSTRIES, INC.	DWG TITLE: AS350 CABLE CUTTERS KIT						
	APPROVED BY ENGR Sand MFG Davy Bach	- ac Mount fera	eff' NEXT ORDER				
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: CREATED FIXED AND CCK WITHO		KIT				
SHEET 1,	BOM, IS:  BOM, IS:  DAS  SEFETENCE CILLY	1	ACKET    NSZPR99-1-18     NSZPR99-1-19     NSZPR99-1-19     NSZPR99-1-21     NSZPR99-1-21     NSZPR99-1-21     NSZPR99-1-21     NSZPR99-1-22     NSZPR99-1-22     NSZPR99-1-22     NSZPR99-1-22     NSZPR99-1-22     NSZPR99-1-22     NSZPR99-1-22     NSZPR99-1-23     NSZPR99-1-24     NSZPR99-1-25		REF   REF   GS   G475701   GPS   MOUNT   KITY   MISSISSISSISSISSISSISSISSISSISSISSISSISS	26   601,283   SURE	RESPONDED TO THE RESERVE TO THE RESERVE TO THE RESERVE TO THE RESPONDED TO THE RESERVE TO THE RE
DOCUMENTS EFFECTED:	⊠ MDL ⊠ INSTALL INSTRUC ⊠ ICA ⊠ I		REVIEW REQUIRED. YES Ø NO				